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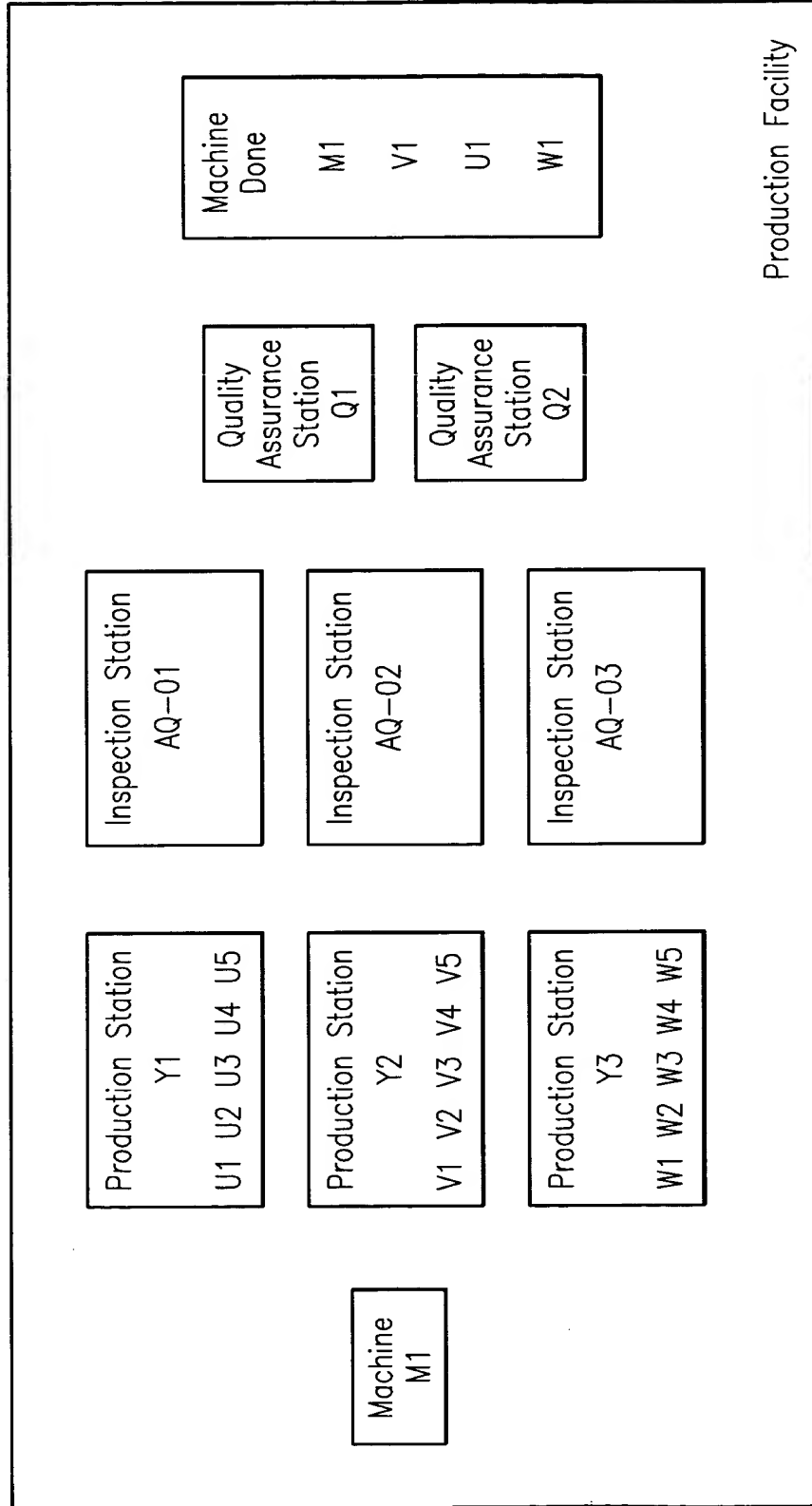


FIG. 1



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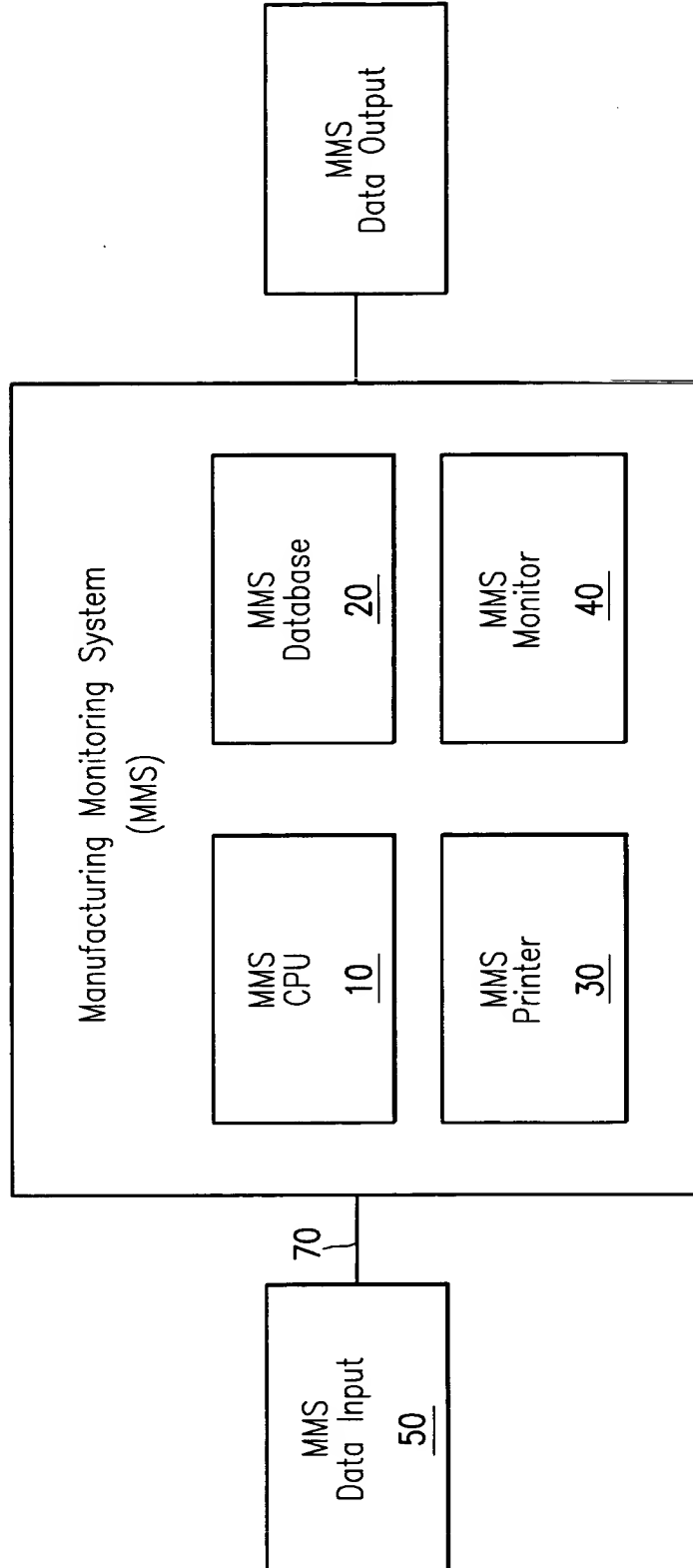


FIG. 2



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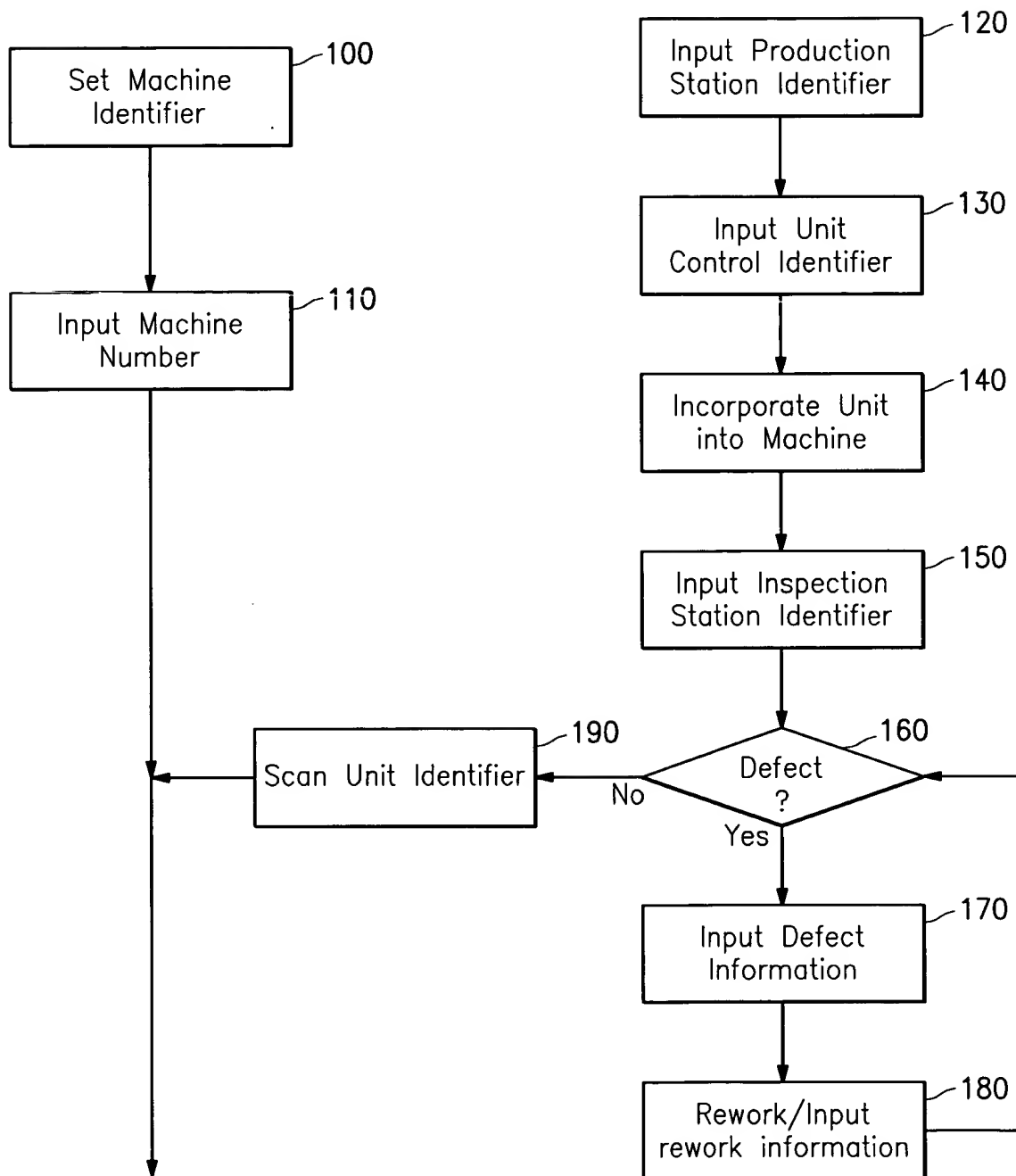


FIG. 3



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192

Serial No.

Machine No.

QA Insp.Name Inspection Date

Alicia - 00073
Ellen - 02120
Em - 01945
Heriberta - 00369
Rita - 00406
Rosa - 02365
Socorro - 00461
Victor - 04508

Log on

Log off

Exit

Date X

Month

List All QA Insp. Mach.

List All QA defect

Print Out Traveler

191

193

Insp.Station

Employee #

Defect Time

Defect

Grade

Repair

Responsible

TTR Name

Insp.Recheck Name

Note

194

195

197

198

199

188

FIG. 3A



U.S. Serial No.: 9/827,507
Filing Date: April 6, 2001
Title: APPARATUS AND METHOD FOR MONITORING
MANUFACTURING STATUS
Inventor(s): Tri Minh Nguyen
Hogan & Hartson Docket No.: 81855.0008
Replacement Sheet

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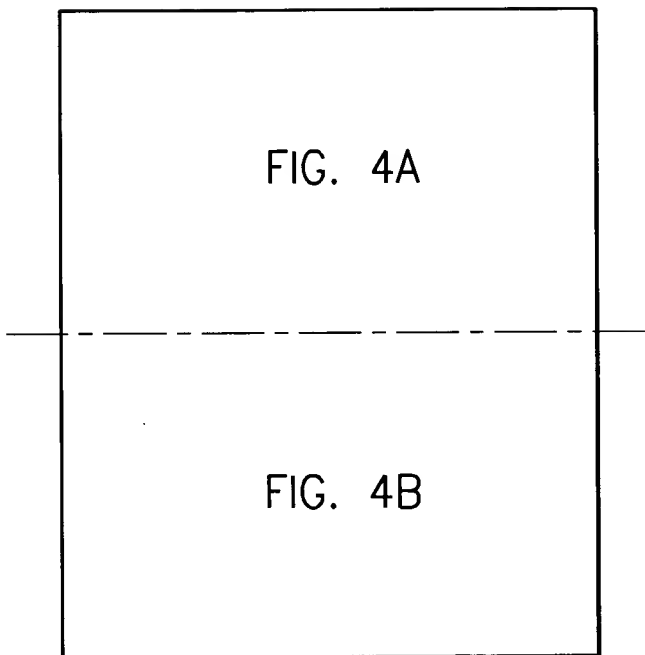


FIG. 4

FIG. 4A



U.S. Serial No.: 9/827,507
 Filing Date: April 6, 2001
 Title: APPARATUS AND METHOD FOR MONITORING
 MANUFACTURING STATUS
 Inventor(s): Tri Minh Nguyen
 Hogan & Hartson Docket No.: 81855.0008
 Replacement Sheet

A229-17 120V-60Mz		Traveler - Machine Record		Ricoh Aficio650	
MACHINE NUMBER		MACHINE Serial #			
2299110042		 A 22 917 00 00 00 00 00 00 y			
AU-01	Scanner BICU PCB Serial # Duplex Unit No. Scanner Unit No.	Machine Input Date/Time 11/1/99 11 27:15 AM		Machine Output Date/Time	
AU-02	Fusing Unit No. Controller Unit No. PCU Unit No.	ARDF Serial No.		Beam Pitch 0 8 8 7 3 6 0	
AU-03	Trandem LCT User No. Operation Panel PCB Serial No.	PCI Nos.		Beam Power 9 1 3 0 7 8	
AQ-01	I/O PCB Serial # Power Supply PCB Serial # Paper Bank PCB Serial # Ground Test Insulation Test	Back Front Upper Lower		Slave Developer Tank Voltage # 0 0 7 1 1 1 1 J	
AQ-02	Leakage Test Total Wattage	Beep 10 MOhms or More 3.5 mA Max 1300~1500 Watts		Operation Panel PCB Serial # Paper Feed Unit No. Exit Unit No.	
AQ-03	Total Counter	0000000001~0000010			
AQ-04	High Voltage Test Ground Test	1.25 KV for 2 seconds 0.1 Ohm or Less			

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240

250

260

230

200

210

220

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[illegible]



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Current Data (From Last Working Day 4:00 PM to Today 4:00 PM)

QC Stations

	Def	Insp	Rate	
AQ-01	14	88	0.159	III
AQ-02	6	87	0.069	III
AQ-03	6	85	0.071	III
AQ-04	0	85	0	III
AQ-05	2	83	0.024	III
AQ-06	0	86	0	III
AQ-07	2	85	0.024	III
AQ-08	3	84	0.036	III
AQ-09	1	84	0.012	III
AQ-10	1	84	0.012	III
AU-01	2	88	0.023	III
AU-02	3	76	0.04	III
AU-03	3	75	0.04	III
300	310	320	330	

X

All Models

Q'ty Rate

Prod Main 22 0.262 III

Prod Sub 6 0.072 III

J-7 4 0.048 III

Loc 0 0 III

PCB 1 0.012 III

Eng 0 0 III

QC 0 0 III

No Info 0 0 III

Others 2 0.024 III

Under Rework 7 0.084 III

340 350 360

Total Defect 44 ³⁹⁵

NIC Defect 1 ³⁹⁰

Insp.Q'ty 84 ³⁸⁰

Failer Rate 0.513 ³⁷⁰

Refresh to
Latest Data

Return to
Main Screen

FIG. 5





U.S. Serial No.: 9/827,507
 Filing Date: April 6, 2001
 Title: APPARATUS AND METHOD FOR MONITORING
 MANUFACTURING STATUS
 Inventor(s): Tri Minh Nguyen
 Hogan & Hartson Docket No.: 81855.0008
 Replacement Sheet

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Machine No.	Insp St	Defect	Repair	Respons	Prod	Defect Time
9350050200	AQ-01	Discn cn(2)pin rear mach Fan	Connected	PROD	AE LINE	5/30/00 7:55:36AM
9350050168	AQ-01	Discn cn(273): Paper bank board	Connected the connector	PROD	AE-07	5/25/00 4:53:37PM
9350050177	AQ-01	Harness out of the saddle rear side mach base	Put into the clamp	PROD	AE-02	5/25/00 4:03:44PM
9350050254	AQ-01	Incomplete locked Ferrite Cote	Assy closed (ferrite)	PROD	AC LINE	5/30/00 2:01:58PM
9350050238	AQ-01	Loose rivet: paper bank frame	Retighten	PROD	AW LINE	5/30/00 12:50:25PM
9350050220	AQ-01	M/M Duct fan	Remounted	PROD	AC-05	5/30/00 10:01:01AM
9370050011	AQ-01	M/S ferrite power cord				5/30/00 3:32:19PM
9350050252	AQ-01	M/S screw, Duct fan				5/30/00 3:24:30PM
9350050252	AQ-01	M/S screw, Duct fan(1)	Installed (SCREW)	PROD	AC-01	5/30/00 1:25:52PM
9350050202	AQ-01	M/S screw, Duct fan brkt (1)	Installed the screws	PROD	AE-11	5/30/00 8:11:51AM
9350050248	AQ-01	M/S toner recycle brkt. Screws on rear side	PTA #9 error (installed the saddles)	PROD	AE-02	5/30/00 1:01:58PM
9350050243	AQ-01	Mis-routed black han. Power supply	Assy put correct position(harness)	PROD	AE-LINE	5/30/00 12:37:00PM
9350050177	AQ-01	No display: operation panel	Replace BICU replaced	J-7		5/30/00 4:04:34PM
9350050233	AQ-01	No display: operation panel	Replace scanner PCB	J-7		5/30/00 11:12:52AM
9350050209	AQ-01	No power: machine	BICU CN-301 disconnect(connected)En	PROD	AE-10	5/30/00 9:24:40AM
9350050205	AQ-01	SC 366 light stay on	Replaced BICU pcb	J-7		5/30/00 8:24:02AM
9350050252	H4805300240	AQ-01 MS Screw Doct				
9350050252	H4805300240	AQ-09 Out prime temp scanner harness				
Record	8165	8165 or 8165				

FIG. 6



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500

Production

AA-Line

AB-Line

AC-Line

AD-Line

AE-Line

AF-Line

AG-Line

Total

Main

Sub

AT-Line

AW-Line

510

Defect Analysis

Date

05-30-00

Month

May-00

DailyDefect

Eng.

Other

No Info.

No Charge

Part

In-House

WareHouse

Local

J-7

PCB

Paint

Press

Mold

Handling

Issue

Return to Main Screen

DAILY MOJITO Failure Rate

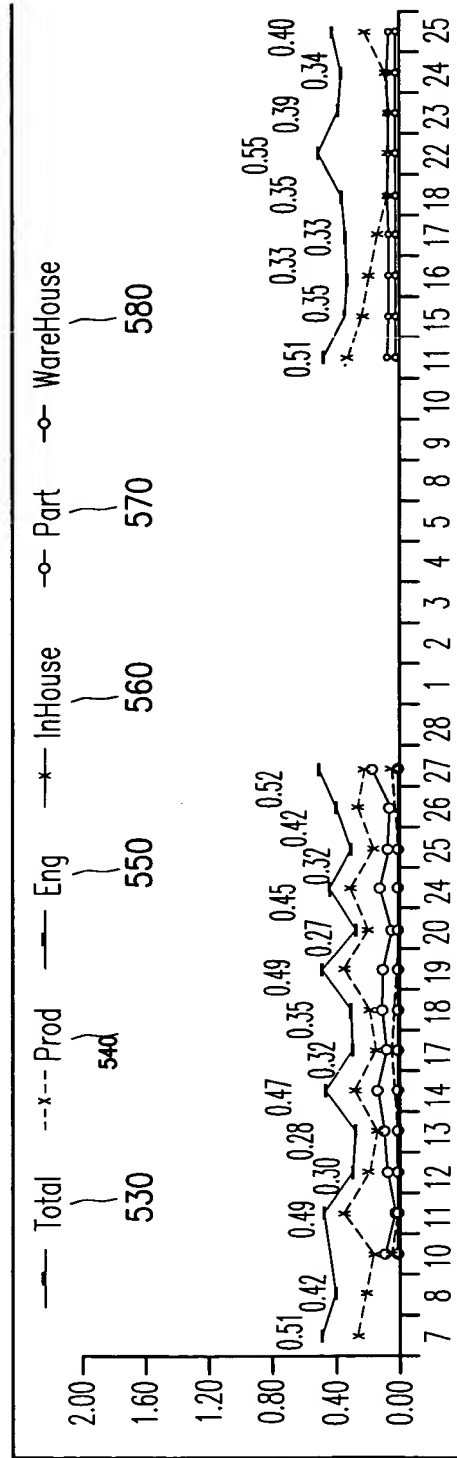


FIG. 7





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Date	Input			QC Output			Packing Output			Work in Progress		
			Total			Total			Total			Total
5/25/00	95		95	93		93	101		101	82	0	82
5/24/00	95		95	100		100	102		102	88	0	88
5/23/00	96		96	105		105	115		115	95	0	95
5/22/00	82		82	78		78	57		57	114	0	114
5/18/00	94		94	85		85	86		86	89	0	89
5/17/00	91		91	87		87	115		115	81	0	81
5/16/00	94		94	90		90	60		60	105	0	105
5/15/00	86		86	90		90	94		94	71	0	71
5/11/00	93		93	85		85	82	5	87	79	0	79
5/10/00	66	7	73	7	68	75	1	74	75	68	5	73
5/9/00		91	91		85	85		84	84	3	72	75
5/8/00		73	73		70	70		81	81	3	65	68
5/5/00		62	62		64	64	1	63	64	3	73	76

FIG. 8



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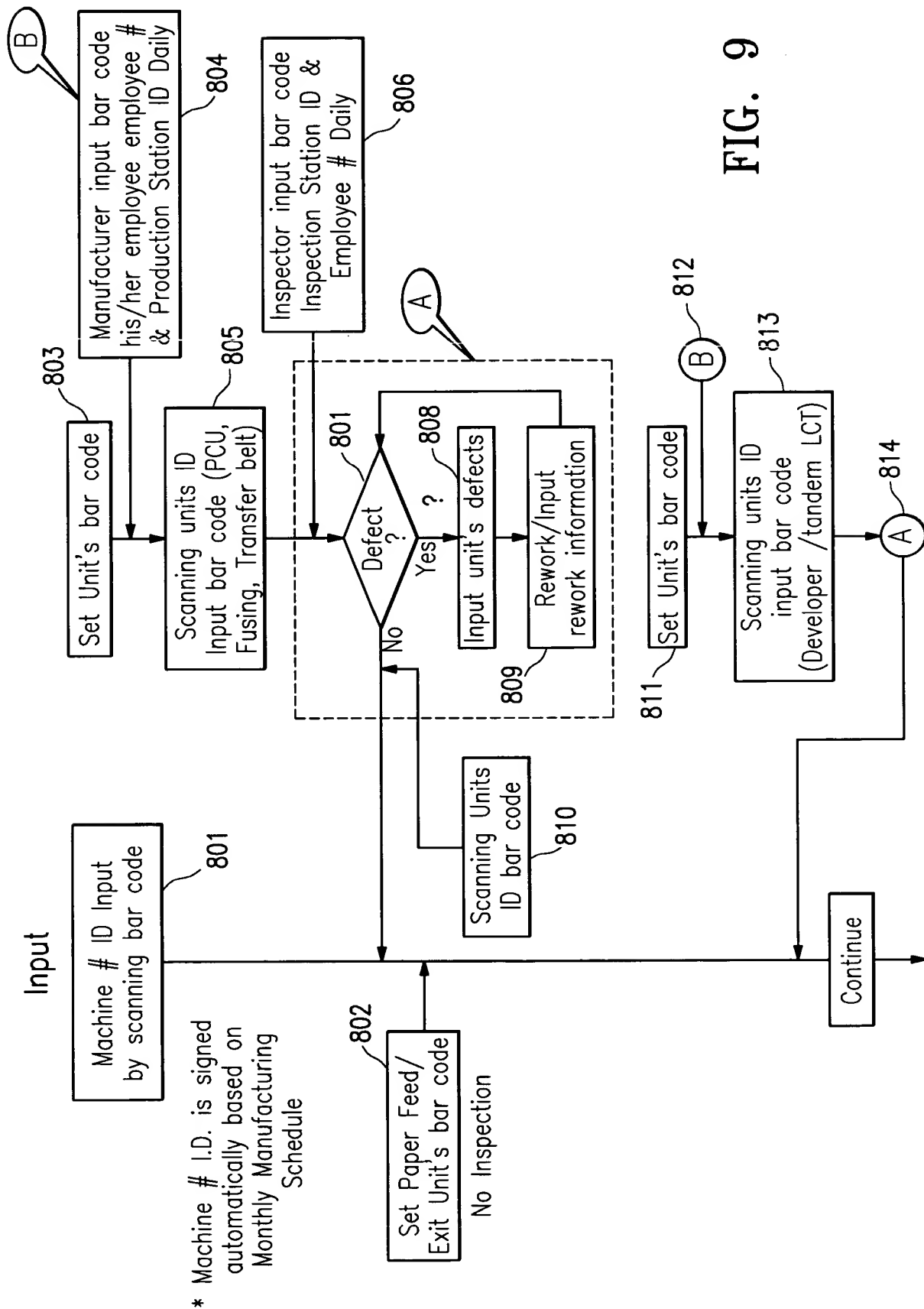


FIG. 9



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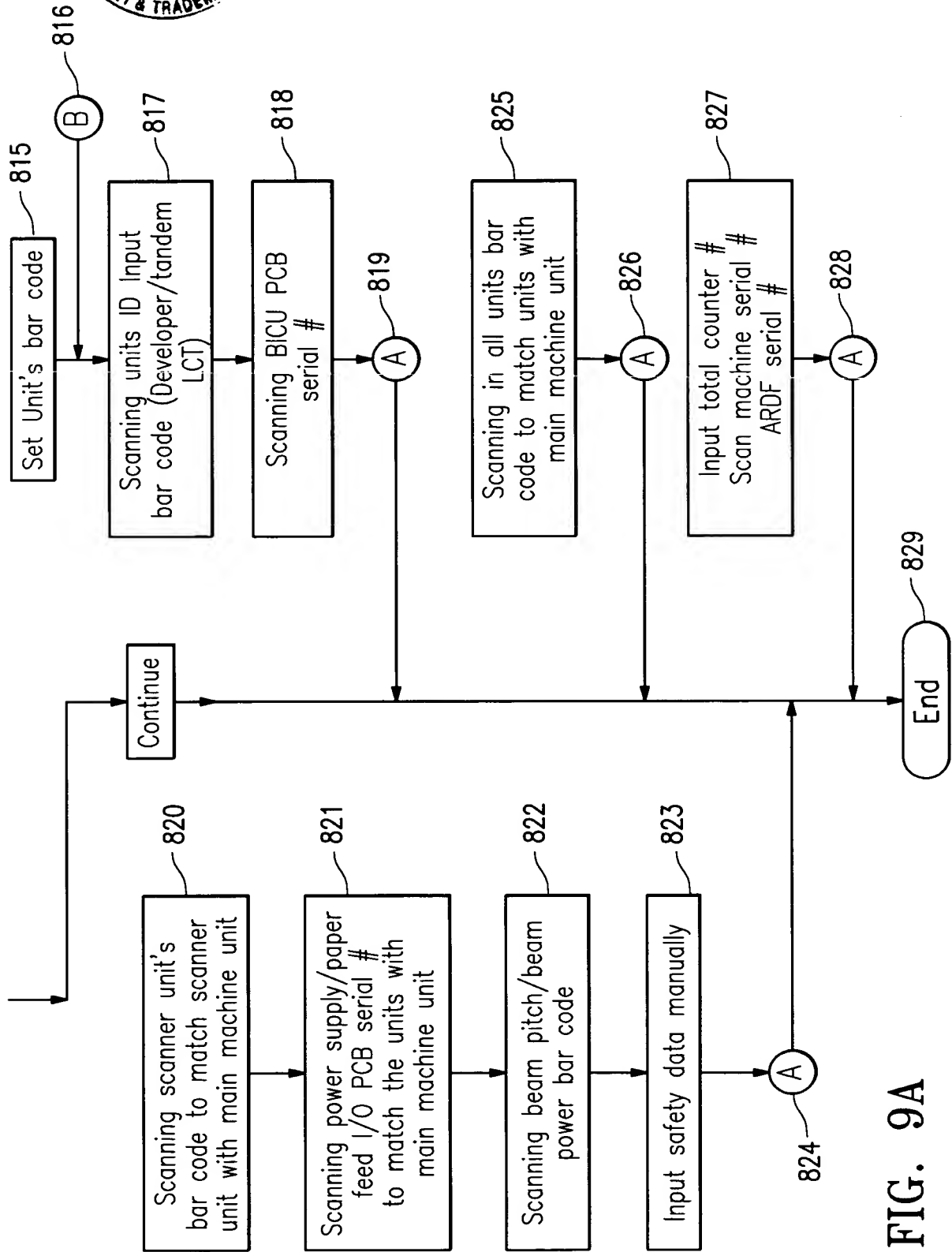


FIG. 9A